



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4462-1

Job Sheet 180681



Part No: D4462-1

Job Qty: 2 ea

Part Name: Baffle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E SHEETS 1,2 IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC IPP REV:B 13.10.28 DWG REV PD1 DD VERF:JLM IPP REV:C 14.06.13 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		7/31/18	0.00	0.00	Start Up Waterjet		SC 18/07/18
100	Waterjet	2 pcs		7/31/18	0.00	0.59	Waterjet1		SC 18/07/18
110	QC	2 pcs		7/31/18	0.00	0.00	QC2 Waterjet-3		SC 18/07/18
120	QC	2 pcs		7/31/18	0.00	0.00	QC8-4		38
130	Brake NC	2 pcs		7/31/18	0.18	0.58	Brake NC 2		SC 9-89
140	QC	2 pcs		7/31/18	0.00	0.00	QC8-5		SEP 18 2018 68
150	HandFinish	2 pcs		7/31/18	0.00	0.31	HandFinish1		DR 18/09/18 68
160	QC	2 pcs		7/31/18	0.00	0.00	QC7-3		SEP 19 2018 68
170	Packaging	2 pcs		7/31/18	0.00	0.00	Packaging3-2		SC 2018-05-18
180	QC21-SA	2 Ea		7/31/18	0.00	0.00	QC21		21 SEP 19 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	4.4000 sf (2.2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	4	287	0

Part Specifications

Specifications could not be found.

Plex 7/12/18 7:25 AM Dart.lajeunesse.marie

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Ret ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		Container No: S102365 Part: D4462-1 Job No: 180681 Serial No/Batch: S102365 Rec/Store/Ret: S102365 Inspector: Various STC's Exp Date: _____ Date: 08/15/18							
Description Work Order Devia _____											
Root Cause <table border="0" style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table border="0" style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Fc ☐ Bending ☐ Centre Not C ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Fc ☐ Bending ☐ Centre Not C ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	<table border="0" style="width:100%;"> <tr> <td style="width:50%;"> Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:50%;"> ned Wrong ☐ e Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>		Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	ned Wrong ☐ e Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER : _____											

DART AEROSPACE LTD		Work Order:	180681
Description: Baffle		Part Number:	D4462-1
Inspection Dwg: D4462 Rev: E		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	Ø0.132	1		VSC-01	
Ø0.768	+0.010/-0.001	Ø0.772	1		Tq/R	
Ø3.50	+0.012/-0.001	Ø3.507	1			
0.660	+/-0.010	0.660	1			
0.38	+/-0.030	0.389	1			
0.750	+/-0.010	0.752	1			
1.74	+/-0.030	1.748	1			
5.77	+/-0.030	5.78	1			
6.50	+/-0.030	6.507	1			
12.44	+/-0.030	12.449	1			
14.16	+/-0.030	14.17	1			
3.75	+/-0.030	3.750	1			
4.12	+/-0.030	4.120	1			
4.28	+/-0.030	4.288	1			
4.65	+/-0.030	4.66	1			
11.21	+/-0.030	11.217	1			
18.29	+/-0.030	18.30	1			
19.81	+/-0.030	19.80	1			
22.38	+/-0.030	22.38	1			
23.55	+/-0.030	23.554	1			
5.05	+/-0.030	5.056	1			
9.31	+/-0.030	9.317	1			
12.54	+/-0.030	12.549	1			

Measured by:	SC	Checked by:	DAS 38 9-89	QC Inspector:	
Date:	18/07/18	Date:	AUG 24 2018	Date:	

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue	KJ	
B	12.05.15	Dimensions updated per Dwg Rev B	KJ	
C	13.05.08	Dwg Rev updated	KJ	
D	15.01.14	Dimensions updated per Dwg Rev C	KJ	
E	15.01.20	Dimensions updated per Dwg Rev E	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS					
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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